

Work Order ID 75128

Monday, October 17, 2011 3:23:14 PM

75128

Oct. 27th

Page 1

Item ID: D3371-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Pedal Lock Assembly

Stop

NS2

Start Date: 10/17/2011 Start Qty: 3.00

3

Cust Item ID:

Required Date: 10/24/2011 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-10-17 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3371	Rev B
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120

120

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

- 1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.
- 2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.
- 3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5
- 4- Assemble lock mechanism and cam and install decal as per Dwg D3371. Apply locktite to lock body nut.

Qty Part Number Description Batch
A/R 262 Locktite HU17851

3
SA 11/10/27

130

130

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Assemble lanyard to cyclic sock as per Dwg D3384
Identify as D3384-045

SB 11/10/27
3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

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Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Pedal Lock Assembly

Stop

NS2

Start Date: 10/17/2011 Start Qty: 3.00

3

Cust Item ID:

Required Date: 10/24/2011 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
Description

170

QC21- Final Inspection - Work Order Release

170

QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

C420A

11/10/27 JG

MF
11-10-27

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, October 17, 2011 3:23:13 PM

Page 1

Work Order ID: 75128

Parent Item: D3371-041

Parent Item Name: Pedal Lock Assembly

Start Date: 10/17/2011

Required Date: 10/24/2011

Start Oty: 3.00

Required Qty: 3.00

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-028 3/16" Dowel Pin .5" long		Purchased	No			120	Each	224.0000	2	6	Sa	4/10/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST399		224							
				106673		98							
				108114		99					C		
				17848		27							
AN526C832R6 Screw		Purchased	No			120	Each	330.0000	4	12	Sa	11/01/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST327		330							
				16612		330							
AN960-416 Washer	NAS1149F0463P	Purchased	No			140	Each	0.0000	7	116.702	T2		
CBL-1240 Cable		Purchased	No			130	f	1,000.6014	1.6666	5.2629474	Sa	6 11/10/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		500							
				119021		500							
				ST284		500.601431							
				113565		6.311789							
				116438		194.289642							
				118207		300					5.262		

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, October 17, 2011 3:23:14 PM

Page 2

Work Order ID:	75128	Parent Item:	D3371-041	Start Date:	10/17/2011	Required Date:	10/24/2011
Parent Item Name:	Pedal Lock Assembly			Start Qty:	3.00	Required Qty:	3.00
CBL-460 Loop Sleeve	Purchased	No		130	Each	601.0000	2 <i>Sb 6 11/01/27</i>
			<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>	
			GA	200			
			119021	200			
			ST283	13			
			117947	13			
			ST284	388			
			118140	388			
D2728-7 Dart Logo label	Manufactured	No		120	Each	0.0000	0 <i>Sb 0 11/01/27</i>
D3371-1 Pedal Lock Base	Manufactured	No		120	Each	1.0000	1 <i>Sb 3 11/01/27</i>
			<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>	
			ST485	1			
			70040	1			
D3371-3 Pedal Lock Cover	Manufactured	No		120	Each	0.0000	1 <i>Sb 3 11/01/27</i>
D3373-7 Cam Lock	Manufactured	No		120	Each	0.0000	1 <i>Sb 3 11/01/27</i>
D3384-1 Cyclic Sock	Manufactured	No		130	Each	0.0000	1 <i>Sb 3 11/01/27</i>
D3385-3 Hinge	Manufactured	No		120	Each	102.0000	1 <i>Sb 3 11/01/27</i>
			<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>	
			ST051	102			
			22387	102			
HX-81 1/4"-20 SHCS 3/8" long	Purchased	No		140	Each	20.0000	1 <i>Sb 3 11/01/27</i>
			<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>	
			ST390	20			
			114383	20			

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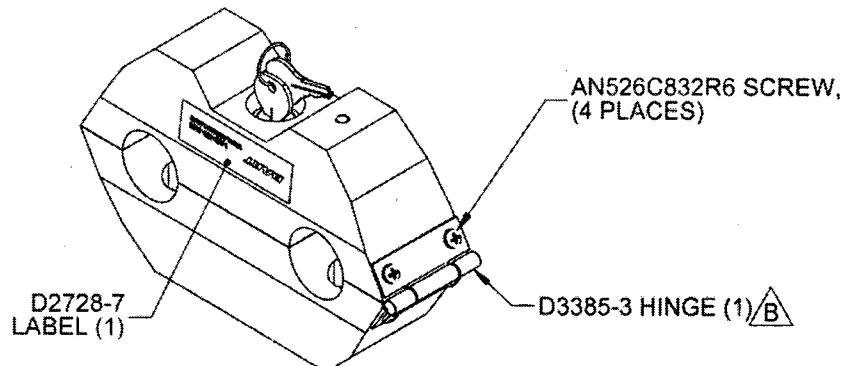
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

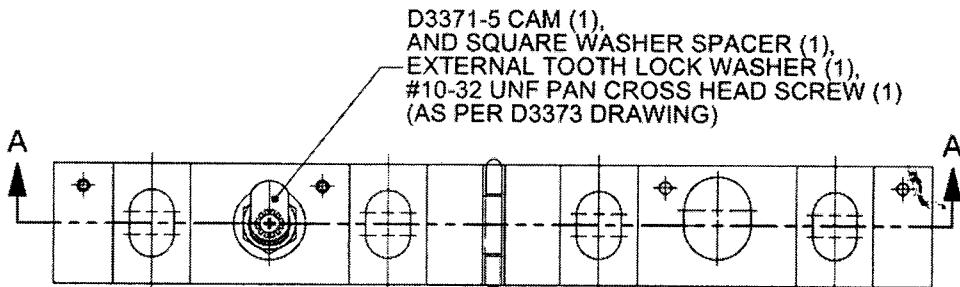
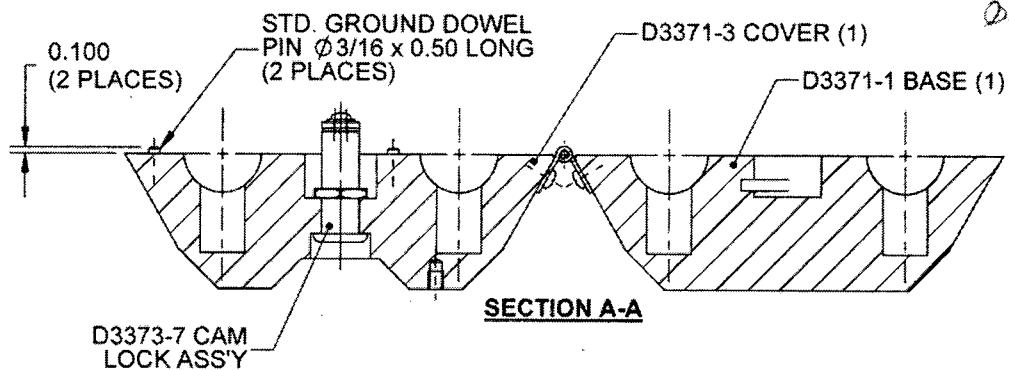


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
#	MP	D3371	SHEET 1 OF 4
DATE	05.03.22	TITLE	SCALE
		PEDAL LOCK	1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED
05/04/28



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
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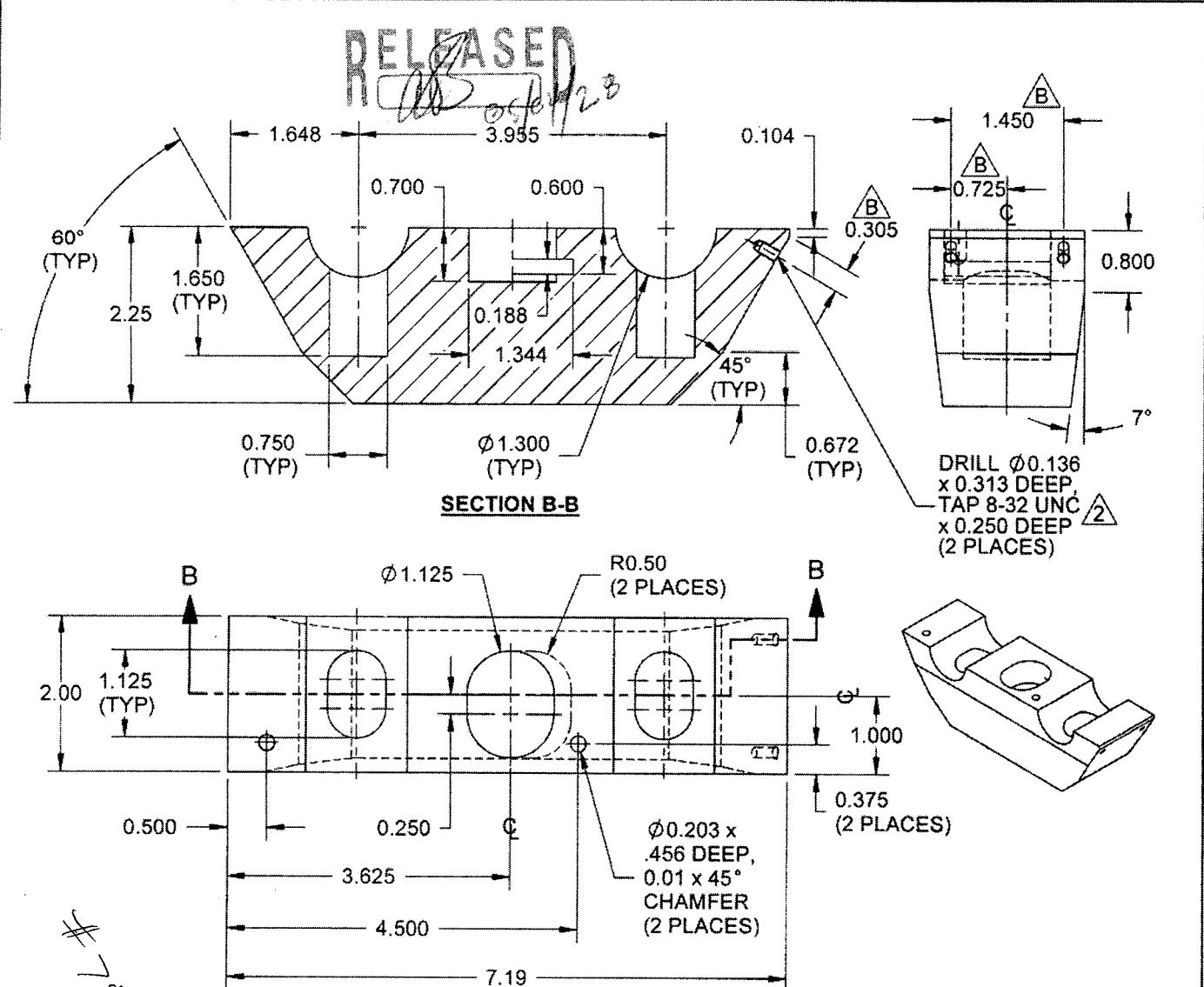
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CHECKED	APPROVED	DRAWING NO. D3371	
DATE	05.03.22	TITLE	PEDAL LOCK

REV. B
SHEET 2 OF 4
SCALE
1:2



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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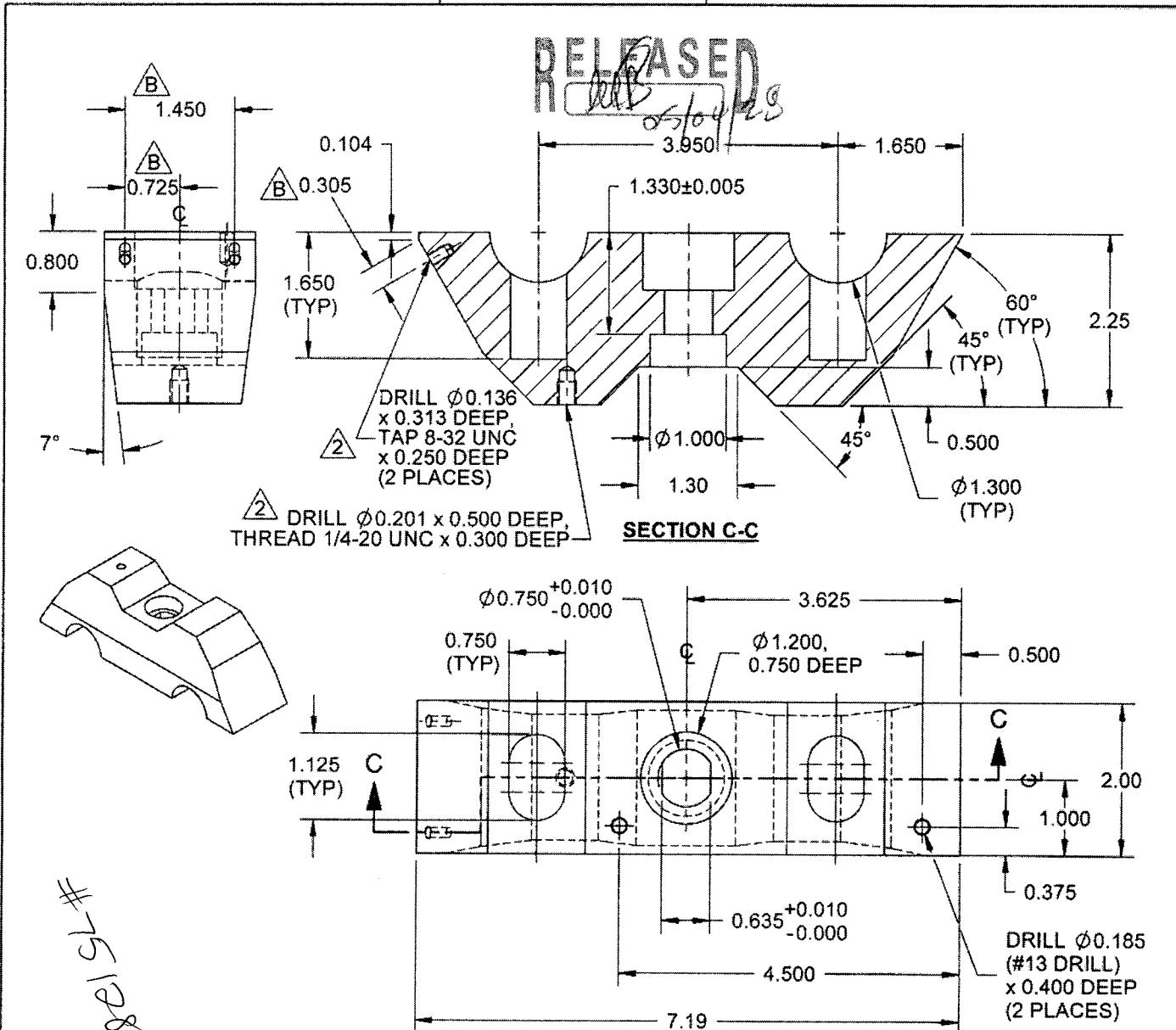
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
P		D3371	SHEET 3 OF 4

DATE

05.03.22

TITLE

PEDAL LOCK

SCALE
1:2

D3371-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
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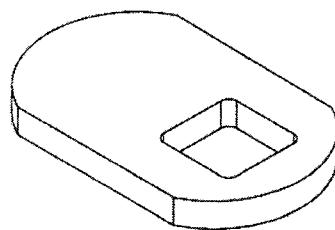
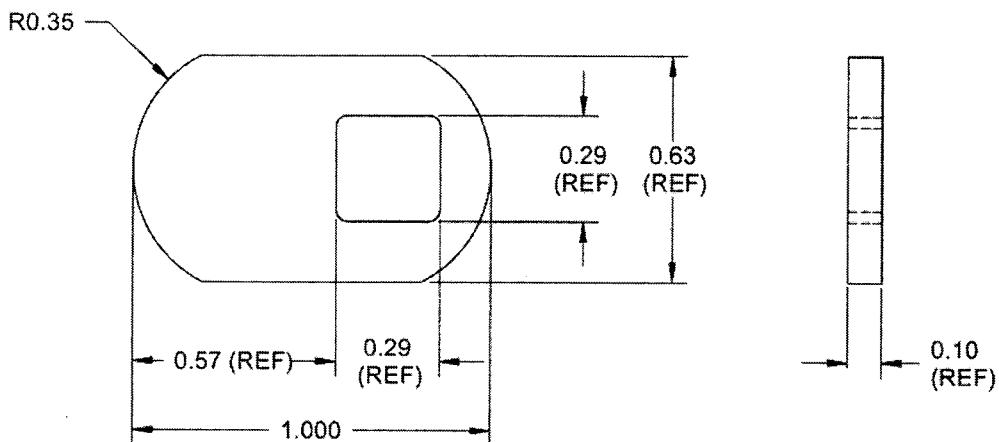
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	D3371	REV. B SHEET 4 OF 4
DATE	05.03.22	TITLE	PEDAL LOCK	SCALE 2:1

RELEASED
05/04/20

SPECIFICATION CONTROL DRAWING



Design #

D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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